

Work Order ID 50838

July 31, 2009 8:33:39 AM



Page 1

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 08/06/2009 Start Qty: 1.00
Required Date: 08/28/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: mf Date: 09-07-31 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A on WO 51023

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 0 BE 09/07/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 50838






July 31st, 2009 8:33:39 AM

Page 2

Item ID:	D205-634-041	Accept		Setup	Start	
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Item Name:	Replacement Skidtube					
Start Date:	08/06/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	08/28/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
									
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends								
	2- C'sink holes as per dwg without cutting fluid								
	3- Prepare tube for welding, remove alodine as required.								
	4- Scribe batch number insied aft end of tube.								
130	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									



9-7-31

8 09/07/31



W/O:		WORK ORDER CHANGES					
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July 31, 2009 8:33:39 AM



Page 3

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140		0.00							
-----	--	------	--	--	--	--	--	--	--



Skidtubes		0.00							
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Skidtubes									
-----------	--	--	--	--	--	--	--	--	--

Memo

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

m110295

BE 09/08/04

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

m110296

BE 09/08/04

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

- AWM 9-8-5

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July 31, 2009 8:33:39 AM



Page 4

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ 8 09/08/05			(X1)			
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8 09/08/05			(X1)			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00	⇒ 09-08-06		(X1)	Jef			

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Page 5

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Required Date:	08/28/2009	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo M112260 START TIME: 8:45AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:15AM	0.00 0.00							
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

=> 09-08-06 (X) JV

BK 09-08-6 (7)

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Page 6

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Required Date:	08/28/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
	HandFinish								
Hand Finishing	Memo	0.00				X1			
	<p>1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> m111557 Sikaflex expire date: 10/01</p> <p>2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580</p> <p>3-Inspect for foreign object per QSI 024</p> <p>4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> m111557 Sikaflex expire date: 10/01</p> <p>5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: m112106</p>								

m11 09/08/06

W/O:		WORK ORDER CHANGES					
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Picklist Print

July 31, 2009 8:33:39 AM

Page 1 / 9

Work Order ID: 50838

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 08/06/2009

Required Date: 08/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2580-1RevD

Manufactured

No

110

Each

7.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

48616

1

50760

6

B 50758 D 119-7-31

D2576-3RevG

Manufactured

No

140

Each

165.0000

1.0000



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

165

43504

62

46661

103

1 BE 09/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

July 31, 2009 8:33:39 AM

Work Order ID: 50838



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Parent Item Name: Replacement Skidtube

Start Date: 08/06/2009

Required Date: 08/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			
Crossbolt Spacer												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

412

43988

4

46434

4

46956

12

47797

338

48272

54

20 08 09/08/04

D2855RevA

Manufactured No

200

Each

66.0000

1.0000



Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP6

52

50513

52

Main Warehouse

ST

14

10360

2

35663

7

41340

1

42343

3

42806

2

50513

-1

X1 09/08/06

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 2

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Page 3

July 31, 2009 8:33:39 AM

Work Order ID: 50838



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube


Start Date: 08/06/2009

Required Date: 08/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A  Bolt		Purchased	No			200	Each	2,560.000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2560

100188

246

105057

2246

15205

68

X2 MD 09/08/09

AN960JD10L



Washer

Purchased

No

200

Each

6,911.000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6911

101291

16

104885

153

105793

236

109632

1506

110985

5000

X2 MD 09/08/09

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 3

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July 31, 2009 8:33:39 AM

Page 4

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Comments:

Start Date: 08/06/2009

Required Date: 08/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			

Insert

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse	110511		
ST		3706	
105855		16	
108606		52	
111529		1638	
111779		2000	

X50 MD 09/08/09

AN3C4A

Purchased

No

200

Each

2,071.000

50.0000

BOLT

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		2071	
112082		121	
112314		1950	

X50 MD 09/08/09

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 4

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Page 6

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D3566-5RevC

Manufactured

No

200

Each

22.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

36113

1

46186

1

47318

1

48167

19

D3566-1RevC

Manufactured

No

200

Each

34.0000

2.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

46349

1

47434

2

48165

8

48557

11

50278

12

X1

MD 09/08/06

X2

MD 09/08/06

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 6

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Page 7

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D3564-11RevD		Manufactured	No			200	Each	30.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

30

45823

1

47432

7

~~48553~~ OK

12

50112

10

X1 MD 09/08/06

D3564-13RevD

Manufactured

No

200

Each

55.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

35

48554

13

50270

22

Main Warehouse

ST

20

45409

3

46495

10

47867

7

X1 MD 09/08/06

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 7

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Page 8

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D3564-9RevD		Manufactured	No			200	Each	17.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	17	
44659	1	
45825	1	
47316	4	
48556	11	

XI MD 09/08/06

D3564-5RevD



Manufactured No

200 Each 22.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	12	
48555	12	
Main Warehouse		
ST	8	
45824	1	
47433	1	
48164	6	

XI MD 09/08/06

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 8

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Page 9

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D2594-3RevC		Manufactured	No			200	Each	894.0000	16.0000			

O-Ring, 205 Skidtube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

894

27168

44

29908

850

X16 MD 09/08/06

D2594-1RevC

Manufactured No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

700

42221

16

42807

92

43884

87

46435

3

47251

502

X16 MD 09/08/06

July 31, 2009 8:33:39 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
07-Dec-28

Diagram illustrating the grinding and flushing locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Diagram illustrating the assembly of a bolted joint. The components and dimensions are labeled as follows:

- #0.208 DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- AN3-5A BOLT (1)
- AN960J10L WASHER (1) (2 PLACES)
- D2855 CAP
- SEAL WITH SIKAFLEX-241/-291
- 0.40

Diagram illustrating the components and inspection steps for a wheel assembly:

- D2579 SPACER**: Points to the central hub area.
- D2596 WEB (REF)**: Points to the spokes.
- ALS7-1032-130 (REF) (TYP 50 PLACES)**: Points to the rim.
- AFTER PERFORM**: Points to the inspection area.
- 1. CHA**: Check for cracks.
- 2. INS**: Inspect for damage.
- 3. WEI**: Weigh the wheel.
- 4. C'B**: Check for balance.

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2598 WEB
3
7
1.750
1.750
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

[illegible]

HULL V-17 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D P P P P P P P

8

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

DESIGN	JJ	DRAWN BY	
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W/D 50638

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE			
07.02.27			

DART		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DRAWING NO. D2580		REV. D SHEET 2 OF 3	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding and the location of the ridge on the underside of the D2576.

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{16}$

Technical drawing of a circular base plate with the following components and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circles on the left side of the plate.
- AN3-5A BOLT (1)**: Points to a bolt on the left side of the plate.
- AN96QJD10L WASHER (1) (2 PLACES)**: Points to two washers on the left side of the plate.
- D2855 CAP**: Points to a cap on the left side of the plate.
- SEAL WITH SIKAFLEX-241/-291**: Points to a seal on the right side of the plate.
- SEE NOTE ii)**: Points to a note on the right side of the plate.
- 0.40**: Dimension line indicating a distance of 0.40 units.

Diagram illustrating the assembly of the D2579 spacer. The diagram shows a circular cross-section of the spacer with a central web. The following parts are labeled:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

After drilling and bending assembly, perform the following for #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

W/O 50636

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

Diagram illustrating the geometry of a horizontal curve. Key dimensions and callouts include:

- 5.985 (offset from tangent to hole center)
- 5.338 (REF) (offset from tangent to hole center)
- 51.340 (total curve length)
- 39.580 (distance from hole center to end of curve)
- 5.915 (offset from tangent to hole center)
- ±0.508 (8 PLACES) (hole diameter)
- 20.0 (offset from tangent to hole center)
- ±0.640 (offset from tangent to hole center)
- 1.4 (offset from tangent to hole center)
- 1.0 (DISTANCE BETWEEN HOLE AND TANGENT POINT)
- 13.4 (offset from tangent to hole center)
- 32.0 ± 1.0 (offset from tangent to hole center)
- Callout 4 (triangle symbol)

[illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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2

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[illegible]

DART DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. D
D2580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 205

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: D205 634 041 50835
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Aluminium
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

REFERENCE ONLY

Qualifier P.C. [Signature] Date of Test Coupon 09-07-30

Welder Barday Elliott Date of Test Coupon 09/07/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld